



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-802-029
Job Sheet 182560



Part No: D206-802-029

Job Qty: 1 ea

Part Name: Crew Door Opener LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/28/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC IPP REV:B 11-06-06 AS PER DSI9560 JLM
VERIFIED BY:EC IPP Rev:C 12.07.30 AS PER ECN12-624 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time
					Setup hrs	Run Hrs	Workcenter / Supplier		
90	Start up Operation	1 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Stores/Pkg-1		
105	Packaging	1 pcs	9/7/18	9/7/18	0.00	0.00	Packaging1-3		
110	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC4		
115	DC	1 pcs	9/7/18	9/7/18	0.00	0.00	DC		
120	Packaging	1 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-1		
130	QC21-FG	1 Ea	9/7/18	9/7/18	0.00	0.00	QC21		

Part Op 115 - Photocopy bluefile and create labels per PPP D206-802-029 CHG002
Descriptions: 120 - Identify and pack for shipping as per PPPDD206-802-029

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3552-15	Door Prop	1 Ea (1 ea)	90-Start up Operation	3013036
D3622-5	Ball Stud	2 Ea (2 ea)	90-Start up Operation	5108897
D4110-3	Doubler, Sill	1 Ea (1 ea)	90-Start up Operation	7149781
D4114-1	Door Doubler, LH	1 Ea (1 ea)	90-Start up Operation	7129905
MS20426AD4-5	Rivet	4 Ea (4 ea)	90-Start up Operation	5089538
MS20600-AD4W2	Rivet	32 Ea (32 ea)	90-Start up Operation	FM137459-3
MS21073L5	Anchor Nut	2 Ea (2 ea)	90-Start up Operation	5083550
MS27130-A26	Rivnut	1 Ea (1 ea)	90-Start up Operation	7116521
NAS1149C0532R	Washer	6 Ea (6 ea)	90-Start up Operation	5089242
NAS1149C0563R	Washer	6 Ea (6 ea)	90-Start up Operation	5060989

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3552-15	1	4	0
	D3622-5	2	0	0
	D4110-3	1	8	0
	D4114-1	1	2	0
	MS20426AD4-5	4	2,122	0
	MS20600-AD4W2	32	224	0
	MS21073L5	2	26	0
	MS27130-A26	1	13	0
	NAS1149C0532R	6	307	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No: _____ NC Date: _____ _____ _____	DISPOSITION Rework ☐ Scrap ☐ Use as is ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐	
Cross tube ☐	Water Jet ☐	Engineering ☐												
Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐												
Finishing ☐	Rec/Store/Packaging ☐	Other ☐												
Composite ☐	Supplier ☐													
		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval												
Instructions: TC STC SH10 - 44 Issue def Fabs TC SR029331 Container No: S106827 Part: D206 - 802 - 029 Job No: 182560 Serial No/Batch: S106827 Revision: Inspector: Exp Date: URT Aerospace Ltd. 1270 Aberdeen Street Hawkebury, ON K4A 1K7 CANADA TEL: 1 813 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com														
CAUSE CATEGORY <table style="width:100%;"> <tr> <td style="width:33%;"> Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:33%;"> Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☒ Past Due ☐ </td> <td style="width:33%;"> Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ OTHER: _____ </td> </tr> </table>			Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☒ Past Due ☐	Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ OTHER: _____									
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<table style="width:100%;"> <tr> <td style="width:33%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:33%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>			Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐										
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Part Specifications

Specifications could not be found.

Plex 8/28/18 10:34 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							

Change Record

PAGE 1 OF 1

Part Number: D206-802-029

Description: CREW DOOR OPENER, LH

[illegible]

5.0 PARTS LIST**5.1 D206-802-029/-030 Crew Door Opener Kits**

Qty -029	Qty -030	Part Number	Description
		D206-802-029	CREW DOOR OPENER KIT, LH
		D206-802-030	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
1	1	D3622-5	BALL STUD
1	1	D4110-3	DOUBLER, SILL
1		D4114-1	DOOR DOUBLER, LH
	1	D4114-2	DOOR DOUBLER, RH
4	4	MS20426AD4-5	RIVET
32	32	MS20600AD4W2	RIVET
2	2	MS21073L5	ANCHOR NUT
1	1	MS27130-A26	RIVNUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.2 D206-802-031/-032 Passenger Door Opener Kits

Qty -031	Qty -032	Part Number	Description
		D206-802-031	PASSENGER DOOR OPENER KIT, LH
		D206-802-032	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	2	D3622-5	BALL STUD
	1	D4112-1	AFT SILL DOUBLER
1	1	D4115-5	DOUBLER
1		D4115-041	LITTER DOOR BRACKET ASSY
3		CR3242-5-4	RIVET
2		CR3243-5-4	RIVET
2	4	MS20426AD4-5	RIVET
9	14	MS20600AD4W2	RIVET
1	2	MS21073L5	ANCHOR NUT
3	6	NAS1149C0532R	WASHER
3	6	NAS1149C0563R	WASHER

REFERENCE ONLY